| Work Order ID (Tuesday, July 13, 2010 11 |                       |   |                                       |                       | · .            | \            |               |                 |                  | Page 1         |
|--|-----------------------|---|---------------------------------------|-----------------------|----------------|--------------|---------------|-----------------|------------------|----------------|
|  | 1-201TRN              | . !   | Accept                                |                       |                |              | Se            | tup Star        | 1 18211121 810   |                |
|  |                       | (WEIN) (IN) (DE)  |                                       | Cust Item 1 Customer: |                |              |               | Stop            |                  |                |
|  | Plan:j                | <u> </u>  | 7 Tooling: SPC (Y/N):                 |                       | )ate:<br>)ate: | ·            | R             | un Star<br>Stop |                  |                |
| Sequence ID/<br>Work Center ID           | Operation Description |   | Set Up/<br>Run Hours                  | Tool ID               | Tool#          | Plan<br>Code | Accept<br>Qty | Reject<br>Qty   | Reject<br>Number | Insp.<br>Stamp |
|  | Revision Nbr          |   |                                       | L.                    |                |              |               |                 |                  |                |
| D212-664-241                             | Rev D                 |   |                                       | i                     | <u> </u>       |              | 1             |                 |                  |                |
| Mori Seiki CNC Lathe Large               | 2-Turn                | ATHE LARGE  be with sand & install plugs D' first side as per Folio FA114 ransition lines smooth.         | 0.00<br>0.00<br>T8534 on both ends as | per Folio FA114       |                |              | 01            | 10              | -07              | - 196          |
| 110                                      | QC1- Inspect dimen    | sions to dimension sheet  | 0.00                                  |                       |                |              | -<br>- a N    | 10              | 07               | (80)           |
| QC<br>Quality Control                    | Memo                  |   | 0.00                                  |                       |                |              | - 4 (         | 70              |                  |                |
| Quality Collido.                         | •                     |   |                                       | •                     |                | . *          |               |                 |                  | 4              |
|  | MORI SEIKI CNC        |   | 0.00                                  |                       |                |              | _g.M          | _ 10            | -07              | - 19 0         |
| Mori Seiki<br>Mori Seiki CNC Lathe Large | 2- File<br>3-Rem      | second side as per Folio FA11 transition lines smooth. ove sand and plugs be batch # and part # as per dw | 4                                     | ,                     |                |              |               |                 |                  |                |

- 1

\* .

| W/O:      | İ    |                   | W                          | ORK ORDER CHA      | NGES   |                |      |       |                               |                          |  |
|-----------|------|-------------------|----------------------------|--------------------|--------|----------------|------|-------|-------------------------------|--------------------------|--|
| DATE STEP |      | PR                | OCEDURE CHA                | ANGE               |        | Ву             | Date | Qty   | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
| Part No   |      |                   |                            | Fault Category: No |        |                |      |       |                               |                          |  |
|           | R    | esolution:        |                            |                    |        |                |      |       | Date: _                       |                          |  |
| NCR:      |      |                   | WORK ORD                   | ER NON-CONFOR      | RMANCE | (NCR           | )    |       |                               |                          |  |
| DATE      | STEP | Description of NC | Initial Action Description |                    |        | Cian 0         |      | ation | Approval                      | Approval                 |  |
|           | J    | Section A         | Chief Eng                  | Chief Eng          | ЮП     | Sign &<br>Date | Sect | ion C | Chief Eng                     | QC Inspector             |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               | A                        |  |
|           | d.   |                   |                            |                    |        |                |      |       |                               |                          |  |
|           | i    |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      | ·                 |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      |                   |                            |                    |        |                |      |       |                               |                          |  |
|           |      | 1                 |                            |                    |        |                | 1    |       | 1                             | 1                        |  |

Tuesday, July 13, 2010 11:29:23 AM

| Item | ID: |
|------|-----|
|------|-----|

D212-664-201TRN

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Crosstube Turning Detail

Start Date:

7/13/2010

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

**Customer:** 

Tool ID

Reference:

Approvals:

Required Date: 7/26/2010

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

**Tooling:** 

Date:

Start Run



\_\_\_\_\_ Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Code

Stop

Qty

Sequence ID/ Work Center ID

130

**Quality Control** 

Operation Description

QC1- Inspect dimensions to dimension sheet

**Run Hours** 

0.00

0.00

Qty

Accept

Reject Reject Insp. Stamp Number

140

Quality Control

Memo

OC8- Inspect parts - second check

0.00

Memo

0.00

150 HandFXtube

Hand Finishing Crosstubes

Crosstubes Chemical Conversion

0.00

Memo

0.00

Chemical Conversion Coat as per within 24 hours of machining

| W/O:    |                                    |                   | W                           | ORK ORDER CHANG              | ES    |        |       |        |                                     |                          |
|---------|------------------------------------|-------------------|-----------------------------|------------------------------|-------|--------|-------|--------|-------------------------------------|--------------------------|
| DATE    | STEP                               | PROCEDURE CHANGE  |                             |                              |       |        | Date  | Qty    | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |                                    |                   |                             |                              | ,     |        |       |        |                                     |                          |
|         |                                    |                   |                             | ,                            | `     |        |       |        |                                     |                          |
|         |                                    |                   |                             |                              |       |        | ***** |        |                                     |                          |
|         |                                    |                   |                             |                              |       |        |       |        |                                     |                          |
|         |                                    |                   |                             |                              |       |        |       |        |                                     |                          |
| Part No | •                                  | PAR #:            | Fault Cate                  | egory:                       | _ NCI | R: Yes | No DG | A:     | Date:                               |                          |
|         | Resolution: Disposition: QA: N/C C |                   |                             |                              |       | N/C CI | osed: |        | Date: _                             |                          |
| NCR:    |                                    | \                 | WORK ORD                    | ER NON-CONFORM               | ANCE  | (NCF   | R)    |        |                                     |                          |
| DATE    | STEP                               | Description of NC | Corrective Action Section B |                              |       | Sign 8 |       | cation |                                     | Approval                 |
| DAIL    | OIL!                               | Section A         | Initial<br>Chief Eng        | Action Description Chief Eng |       |        | Sec   | tion C | Chief Eng                           | QC Inspector             |
|         |                                    |                   |                             |                              |       |        |       |        |                                     |                          |
|         |                                    |                   |                             |                              |       |        |       |        |                                     |                          |
|         | į                                  |                   |                             |                              | ·     |        |       |        |                                     |                          |
|         |                                    |                   |                             |                              |       |        |       |        |                                     |                          |
|         |                                    |                   |                             |                              |       |        |       |        |                                     |                          |
|         |                                    |                   |                             |                              |       |        |       |        |                                     | 1                        |
| •       |                                    |                   |                             |                              |       |        | 5     |        |                                     | :                        |
|         |                                    |                   |                             |                              |       |        |       |        |                                     |                          |
|         |                                    |                   |                             |                              | · ·   |        |       |        |                                     |                          |

Quality Control

| Tuesday, July 13               | , 2010 11:29           | 9:23 AM                            |                                 | • INDIIO NIIII 841   |                     |        |              |               |              |                     |                      |
|--------------------------------|------------------------|------------------------------------|---------------------------------|----------------------|---------------------|--------|--------------|---------------|--------------|---------------------|----------------------|
| Item ID: Revision ID:          | D212-664-2             | 01TRN                              |                                 | Accept               |                     |        |              | s s           | etup S       | 110000000           |                      |
|                                | Crosstube Tu           | rning Detail                       |                                 |                      |                     |        |              |               |              | Stop                |                      |
| Start Date:<br>Required Date:  | 7/13/2010<br>7/26/2010 | Start Qty: 1.00<br>Req'd Qty: 1.00 | <b>184</b> 00   1<br>  1860   1 |                      | Cust Item Customer: |        |              |               |              |                     |                      |
| Reference:                     |                        |                                    |                                 |                      | i                   |        | _            |               | Run S        | Start               | INIIN'INI (KATI (AN) |
| Approvals:                     | Process Pla            | an:                                | Date:                           | Tooling:             | D                   | Date:  |              | r             |              |                     |                      |
|                                | QC:                    |                                    | Date:                           | SPC (Y/N):           | D                   | Date:  |              |               | 1            | Stop                |                      |
| Sequence ID/<br>Work Center II | <b>D</b>               | Operation Description              | ., 1                            | Set Up/<br>Run Hours | Tool ID             | Tool # | Plan<br>Code | Accept<br>Qty | Rejec<br>Qty | ct Reject<br>Number | Insp.<br>Stamp       |
| 160                            |                        | QC3- Inspect Part Finish           | 1                               | 0.00                 |                     |        |              | 1<br> -       |              |                     |                      |
|                                |                        | Memo                               |                                 | 0.00                 |                     |        |              | a.M.          |              | , 07                | 190                  |
| Quality Control                |                        |                                    |                                 |                      |                     |        |              |               |              | 1                   | In Id                |
| 170                            |                        |                                    |                                 | 0.00                 |                     |        |              |               | ~            | /;                  | 1w/1                 |
|                                |                        | Packaging                          |                                 |                      |                     |        |              | i<br>i        |              | 10                  | 0-07-19              |
| Packaging                      |                        | Memo                               |                                 | 0.00                 |                     |        |              |               |              |                     |                      |
| Packaging                      |                        | Identify and Location:             | d stock in kanban rac           | e CCC                |                     |        |              |               |              |                     |                      |
| 180                            |                        | QC21- Final Inspection             | - Work Order Relea              | se 0.00              | •                   |        |              |               |              |                     | · Proorz             |
| QC                             |                        | Memo                               |                                 | 0.00                 |                     |        |              |               |              |                     |                      |

| W/O:                                  |      | WORK ORDER CHANGES |                                       |                              |         |        |         |       |                          |              |  |
|---------------------------------------|------|--------------------|---------------------------------------|------------------------------|---------|--------|---------|-------|--------------------------|--------------|--|
| DATE S                                | STEP | PRO                | OCEDURE CH                            | ANGE                         |         | Ву     | Date    | Qty   | Approval<br>QC Inspector |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       | Prod Mgr                 |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
| · · · · · · · · · · · · · · · · · · · |      |                    |                                       |                              |         | -      | -       |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
| ****                                  |      |                    |                                       |                              |         |        |         |       |                          |              |  |
| Part No:                              |      | PAR #:             | PAR #: Fault Category: NCR: Yes No DQ |                              |         |        |         |       | QA: Date:                |              |  |
|                                       | R    | esolution:         | Dispositi                             | ion:                         | QA      | N/C CI | osed:   | Date: |                          |              |  |
| NCR:                                  |      |                    | WORK ORI                              | DER NON-CONFORM              | IANCE   | (NCF   | 1)      |       |                          |              |  |
| DATE                                  | STEP | Description of NC  | Initial                               |                              | ction B | Sign 8 | Verific |       | Approval                 | Approvai     |  |
|                                       | 0.2. | Section A          | Chief Eng                             | Action Description Chief Eng |         | Date   | Sect    | on C  | Chief Eng                | QC Inspector |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       | <u>E</u>                 |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |
|                                       |      |                    |                                       |                              |         |        |         |       |                          |              |  |

**Picklist Print** Tuesday, July 13, 2010 11:29:28 AM Work Order ID: 60529 D212-664-201TRN Parent Item: Start Date: 7/13/2010 Required Date: 7/26/2010 Parent Item Name: Crosstube Turning Detail Required Qty: 1.00 Start Qty: 1.00 IPP Rev:A 08-03-06 new issue DD verified by:ec Comments: IPP Rev B 08.04.02 Removed polish EC verified DD Qty per Kit Total Unit of Qty on **Qty** Date Replacement Mfg/ Primary Last Route Component Item ID/ Bin Hand Location Seq ID Measure Issued Issued Item Location Item Name Item ID Purch Qty Each 43.0000 No 120 D6006-129 Manufactured 10.07-19/0 Crosstube Material Loc Code Location Loc Qty

LG 43 2 23970 26550 14 11 34690 16 38338

Page 1

Status

| Dart Aerospace Li | td |
|-------------------|----|
|-------------------|----|

| Dart Ae | rospace L | td                |                      |                              |           |           |          |                                     | -                        |
|---------|-----------|-------------------|----------------------|------------------------------|-----------|-----------|----------|-------------------------------------|--------------------------|
| W/O:    |           | <u> </u>          | WC                   | ORK ORDER CHANGE             | S         |           |          |                                     |                          |
| DATE    | STEP      | PRO               | OCEDURE CHA          | NGE                          | Ву        | Date      | Qty      | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |           |                   |                      |                              |           |           |          |                                     |                          |
|         |           |                   |                      |                              |           |           |          |                                     |                          |
| Part No | :         | PAR #:            | Fault Cate           | gory:                        | NCR: Yes  | No DQ     | ļ:       | _ Date: _                           |                          |
|         | Res       | olution:          | Dispositio           | QA: N/C C                    | losed:    | Date:     |          |                                     |                          |
| NCR:    |           |                   | WORK ORD             | ER NON-CONFORMA              | NCE (NCI  | ₹)        |          |                                     |                          |
| DATE    | OTED      | Description of NC |                      | on B                         | Verifi    |           | Approval | Approval                            |                          |
| DATE    | STEP      | \ Section A       | Initial<br>Chief Eng | Action Description Chief Eng | Sign Date | & Section |          | Chief Eng                           | QC Inspector             |
|         |           |                   |                      |                              |           |           |          |                                     |                          |
|         |           |                   |                      |                              |           |           |          |                                     |                          |
|         |           |                   |                      |                              |           |           |          |                                     |                          |
| 7       |           |                   |                      |                              |           |           |          |                                     |                          |
|         |           |                   |                      |                              |           |           |          |                                     |                          |
|         | 1         |                   |                      |                              |           |           | 1        | 1                                   |                          |

| DART AEROSPACE LTD                                 | Work Order:  | 40529        |
|--|--------------|--------------|
| Description: Crosstube Assembly (205/212 High Aft) | Part Number: | D212-664-241 |
| Inspection Dwg: D212-664-241 Rev: C                |              | Page 1 of 1  |

## FIRST ARTICLE INSPECTION CHECKLIST

| Х | First Article | ٠. |  | Prototype |
|---|---------------|----|--|-----------|
|---|---------------|----|--|-----------|

|      | spection Sheet<br>wing Dimension | Tolerance     | Actual<br>Dimension | Accept | Reject   | Method of<br>Inspection | Comments    |
|------|----------------------------------|---------------|---------------------|--------|----------|-------------------------|-------------|
|      | 0.200                            | +/-0.010      | 0.200               | /      |          |                         |             |
|      | R0.063                           | +/-0.010      | RO.063              | /      |          |                         |             |
|      | 2.990                            | +0.005/-0.000 | 2 990               |        |          |                         |             |
|      | 5.237                            | +/-0.030      | 5.237               |        |          |                         |             |
|      | 2.600                            | +0.005/-0.000 | 2.604               | /_     |          |                         |             |
| _    | 2.686                            | +0.005/-0.000 | 2690                |        |          |                         |             |
| ΕA   | 2.770                            | +0.005/-0.000 | 2.774               |        |          |                         |             |
| SIDE | 2.854                            | +0.005/-0.000 | 2.858               |        |          |                         |             |
| 0,   | 2.938                            | +0.005/-0.000 | 2.942               | /      |          |                         |             |
|      | 3.021                            | +0.005/-0.000 | 3.025               | /      |          |                         |             |
|      | 3.133                            | +0.005/-0.000 | 3.136               | . /    |          |                         |             |
|      | 3.179                            | +0.005/-0.000 | 3 . 63              |        |          |                         |             |
|      |                                  |               |                     |        |          |                         |             |
|      |                                  |               |                     |        | <u> </u> |                         |             |
|      | 0.200                            | +/-0.010      | 0.200               | /      |          |                         |             |
|      | R0.063                           | +/-0.010      | RO.067              |        |          |                         |             |
|      | 2.990                            | +0.005/-0.000 | 2.990               | 4      |          |                         |             |
|      | 5.237                            | +/-0.030      | 5.234               |        |          |                         |             |
|      | 2.600                            | +0.005/-0.000 | 2.604               |        |          |                         |             |
|      | 2.686                            | +0.005/-0.000 | 2.680               | /, ~~  |          |                         | <del></del> |
| B    | 2.770                            | +0.005/-0.000 | 2.774               | 1      |          |                         |             |
| SIDE | 2.854                            | +0.005/-0.000 | 2.858               | /      |          |                         |             |
| S    | 2.938                            | +0.005/-0.000 | 2 942               |        |          |                         |             |
| ર    | 3.021                            | +0.005/-0.000 | 2.025               | /      |          |                         |             |
| '    | 3.133                            | +0.005/-0.000 | 3-136               | 1      |          |                         |             |
|      | 3.179                            | +0.005/-0.000 | 3.183               |        |          |                         |             |
|      | (124.36)                         | +/-0.020      | 124.360             |        |          |                         |             |
| I    |                                  |               |                     |        |          |                         |             |
|      |                                  |               |                     |        |          | ļ                       |             |

Measured by: Audited by: Audited by: Prototype Approval: N/A

Date: 10 07.19 Date: N/A

| Rev | Date     | Change                           | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| Α   | 05.04.27 | New Issue (P/O D412-664-201)     | KJ/JLM     |          |
| В   | 06.03.09 | Tolerance for 5.237 was +/-0.001 | KJ/JLM 100 |          |
| С   | 07.05.08 | Dwg Rev. updated                 | KJ/JLM OK  | <i>Y</i> |
|     |          |                                  | . ()       | •        |

|                    | -            |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
|--------------------|--------------|-----------|--|-----------------------------|-----------------|-------------|-----------------|-------------------------------|--------------------------|----------------------|------------------------------|----------------|-----------|-----------|
| W/O:               |              |           |  | WC                          | RK ORDER CHANGI | ES          |                 |                               |                          |                      |                              |                |           |           |
| DATE STEP          |              |           | PROCEDURE CHANGE                           |                             |                 |             | Date Qty        | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |                      |                              |                |           |           |
|                    |              |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
| ,                  |              |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
| T                  |              |           |  | ,                           |                 |             |                 |                               |                          |                      |                              |                |           |           |
|                    |              |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
| 3                  | <u>.</u>     |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
| Part No:Resolution |              |           | PAR #: Pault Category: Nor: Disposition: Q |                             |                 | NCR: Yes    | No <b>DQA</b> : |                               |                          |                      |                              |                |           |           |
|                    |              | esolution |  |                             |                 | QA: N/C Cld | osed:           |                               |                          |                      |                              |                |           |           |
| NCR:               | ۲            |           |  | WORK ORD                    | ER NON-CONFORMA | NCE (NCR    | )               |                               |                          |                      |                              |                |           |           |
| DATE               | STEP         | . 1       | escription of NC                           | Corrective Action Section B |                 |             | Verification    | Approval                      | Approval                 |                      |                              |                |           |           |
|                    |              | JILI      |  |                             | 0.2.            | •           | •               |                               | Section A                | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C | Chief Eng |
| •                  | ,            | v ! "     |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
|                    |              |           |  |                             | •               |             |                 |                               |                          |                      |                              |                |           |           |
|                    |              |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
|                    |              |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
|                    | *            |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
|                    |              |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |
|                    |              |           |  |                             | •               |             |                 |                               |                          |                      |                              |                |           |           |
| **                 | - **<br>- ** |           |  |                             |                 |             |                 |                               |                          |                      |                              |                |           |           |

| ltem         | Qty<br>-241 | Qty<br>-241B | Part Number    | Description  |
|--------------|-------------|--------------|----------------|--|
| • 1          | X           |              | D212-664-241   | CROSSTUBE ASSEMBLY (205/212 HIGH AFT)  |
| <b>₹</b> + 2 |             | Х            | D212-664-241B  | CROSSTUBE ASSEMBLY (214 HIGH AFT)  |
| -3           | 1           | 1            | D6006-129      | CROSSTUBE  |
| 4            | 2           | 2            | D2940-1        | SUPPORT  |
| 5 -          | 4           | 4            | D3595-063-530  | RUBBER CUSHION   |
| 6            | 4           | 4            | MS21920-28     | CLAMP (OR MS21920-30)  |
| 7            | A/R         | A/R          | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023<br>ADHESIVE (TEXTRON/BELL SPEC. 299-947-100<br>TYPE II, CLASS 2 ADHESIVE) |

#### **GENERAL NOTES:**

1) MATERIAL: MANUFACTURED FROM D6006-129

FINISHED LENGTH = 124.362±0.020

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART QSI 005 4.2 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

UNITS: INCHES UNLESS OTHERWISE NOTED.

BREAK SHARP EDGES: 0.005 TO 0.010 MAX.

IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.

WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)

D212-664-241B = 44.2 lbs (PER IIN-D212-664)

PART IS SYMMETRIC ABOUT CENTERLINE.

RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.

10) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.

11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE

14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SÜRFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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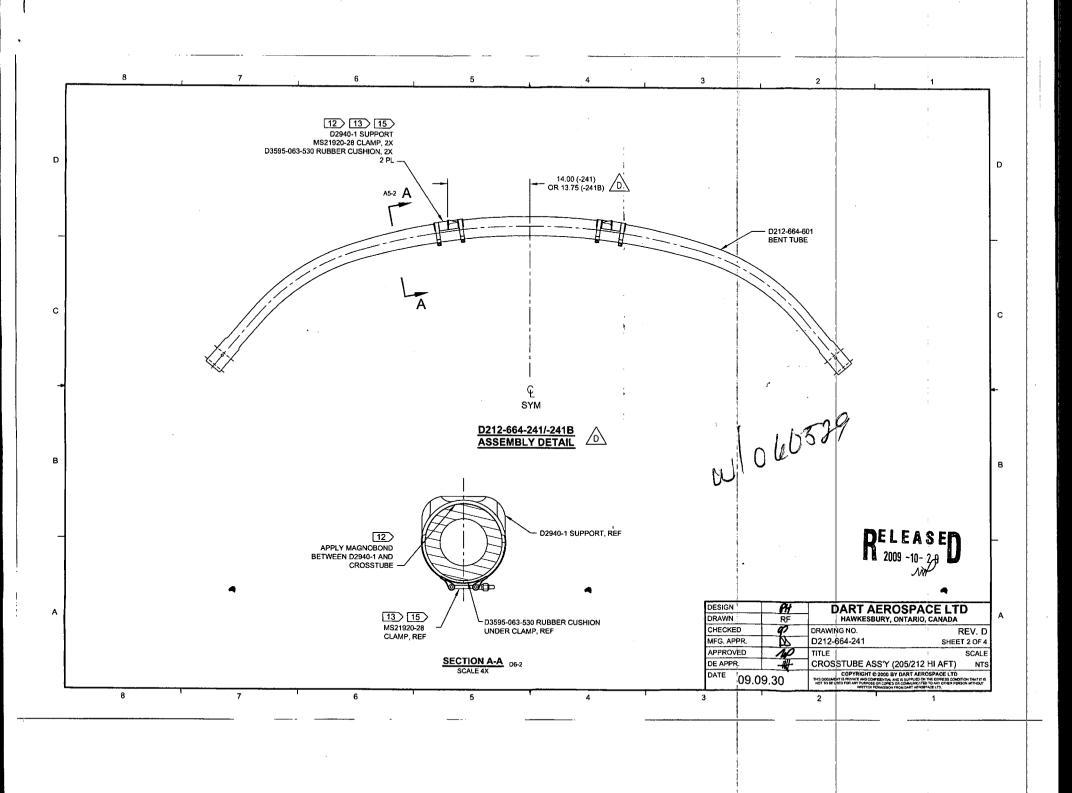
REFORMAT/REVISE GENERAL NOTES/PART LIST: 09 09 30 REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4 REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 07.03.08 6398, CUSHION, REVERSE CLAMPS ADD HOLES FOR COMPATABILITY WITH BHT/AA 05.02.04 R SKIDTUBES NEW ISSUE PH 00.12.12 Α REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RE CHECKED SHEET 1 OF 4 MFG. APPR D212-664-241 TITLE SCALE APPROVED CROSSTUBE ASS'Y (205/212 HI AFT) NTS DE APPR

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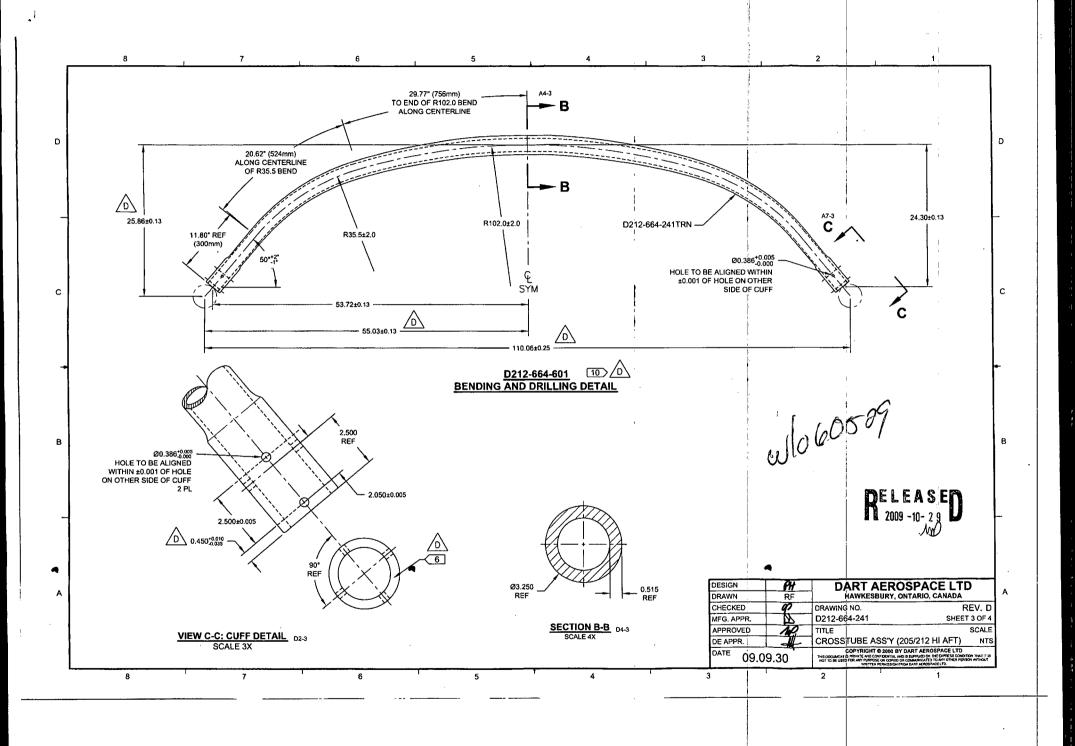
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| W/O:      |             | WORK ORDER CHANGES          |  |  |   |                        |   |     |   |                          |  |
|-----------|-------------|-----------------------------|--|--|---|------------------------|---|-----|---|--------------------------|--|
| DATE STEP |             | PRO                         | PROCEDURE CHANGE   |  |   |                        |   | Qty | Approval Chief Eng / Prod Mgr                 | Approval<br>QC Inspector |  |
|           |             |                             |  |  |   |                        |   |     |   |                          |  |
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| Part No   | ·           | PAR #:                      | PAR #: Fault Category: NCR: Yes No D                                       |  |   |                        |   |     |   |                          |  |
|           | R           | esolution:                  | Disposit   | ion:   | Q | QA: N/C Closed:        |   |     | Date:   |                          |  |
| NCR:      |             | . V                         | WORK ORDER NON-CONFORM   |  |   |                        |   |     |   |                          |  |
| DATE      | STEP        | Description of NC Section A | Corrective Action Sec<br>Initial Action Description<br>Chief Eng Chief Eng |  |   | Sign & Section Section |   |     | Approval<br>Chief Eng                         | Approval<br>QC Inspector |  |
|           |             |                             | Office Ling  | Office Eng   |   | Date                   |   |     |   |                          |  |
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| NOTE: D   | ate & initi | al all entries              | ·  | ····   |   |                        | • |     | <u>,, , , , , , , , , , , , , , , , , , ,</u> | <del></del>              |  |

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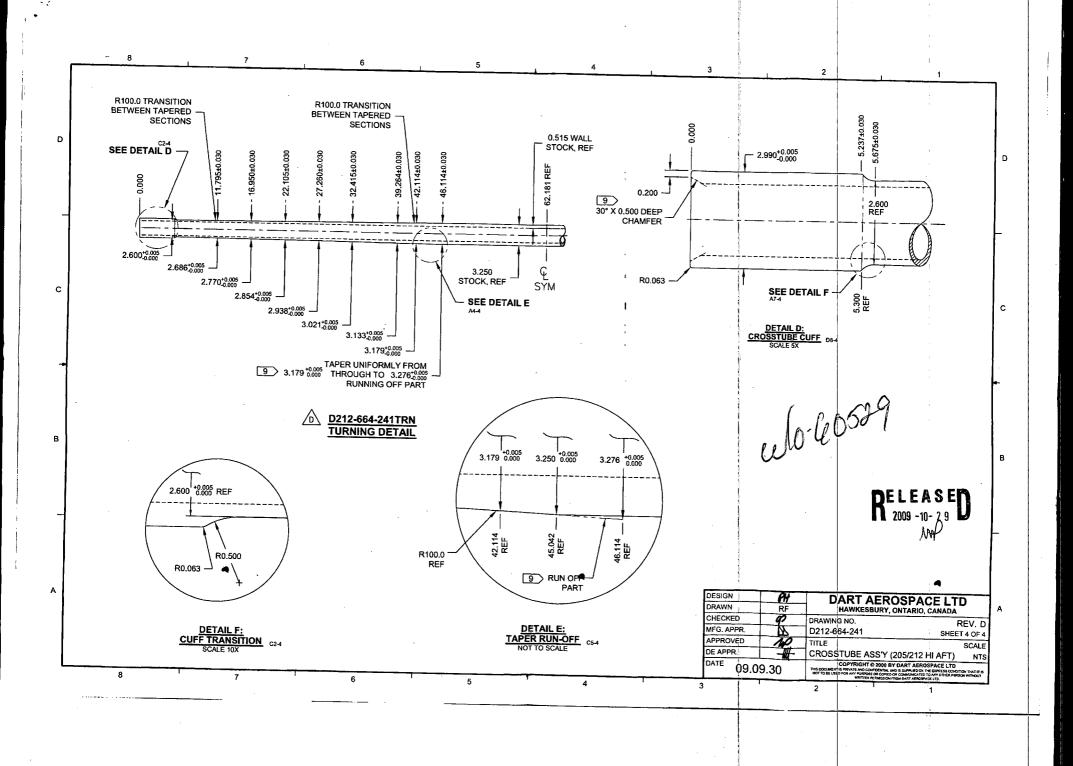


| W/O:    |      |                                | WORK ORDER CHANGES          |   |         |                |                               |                          |                       |                          |
|---------|------|--------------------------------|-----------------------------|---|---------|----------------|-------------------------------|--------------------------|-----------------------|--------------------------|
| DATE    | STEP | PRO                            |                             | Ву  | Date    | Qty            | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |                       |                          |
| Part No |      | PAR #:<br>esolution:           |                             |   |         |                |                               | 1                        |                       |                          |
| NCR:    |      | •                              | WORK OR                     | DER NON-CONFORM                                   | IANCE   | (NCR           | )                             |                          |                       |                          |
| DATE    | STEP | Description of NC<br>Section A | <b>Initial</b><br>Chief Eng | Corrective Action Se Action Description Chief Eng | ction B | Sign &<br>Date | Verifica<br>Section           |                          | Approval<br>Chief Eng | Approval<br>QC Inspector |
|         |      |                                |                             |   |         |                |                               |                          |                       |                          |
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### **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: **Approval Approval** DATE **STEP** Qty PROCEDURE CHANGE By Date Chief Eng / QC Inspector Prod Mar Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_ Date: \_\_\_\_\_ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE STEP Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

Chief Eng Chief Eng Date



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| W/O:        |          |                   | WC                    | RK ORDER CHANG               | ES          |                 |           |                               |                          |  |
| DATE        | STEP     | PRO               | PROCEDURE CHANGE      |                              |             |                 | oty:      | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |
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| Part No:    |          | PAR #:            | Fault Cate            | gory:                        | NCR: Yes    | No <b>DQA</b> : | : Date:   |                               |                          |  |
| Resolution: |          |                   | Disposition           | _ QA: N/C C                  | Date:       |                 |           |                               |                          |  |
| NCR:        |          | V                 | WORK ORDE             | ER NON-CONFORMA              | NCE (NCF    | R)              |           |                               |                          |  |
| DATE        | STEP     | Description of NC | Corrective Action Sec |                              | on B        | VARITICS        |           | Approval                      | Approval                 |  |
| DATE        |          | Section A         | Initial<br>Chief Eng  | Action Description Chief Eng | Sign & Date | Section         | Section C | Chief Eng                     | QC Inspector             |  |
|             |          | • •               |                       |                              |             |                 |           |                               |                          |  |
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